



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2654-1

Job Sheet 172155



Part No: D2654-1

Job Qty: 4 ea

Part Name: Web



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/13/18

Job Tracking No:

Due Date: 2/26/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D2654 REV F SHEET 1 IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM IPP Rev:E 08-06-10 revE1 as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/24/18	0.00	0.00	Start Up Skidtubes-2		JLG
100	Skidtubes	4 pcs		2/24/18	0.00	1.86	Skidtubes-3		PD in 1/17
110	QC	4 pcs		2/24/18	0.00	0.00	QC5		BE
120	HandFinish	4 pcs		2/26/18	0.00	0.64	HandFinish1		SA 18-04-12
130	QC	4 pcs		2/26/18	0.00	0.00	QC7-1		BE
140	Packaging	4 pcs		2/26/18	0.00	0.00	Packaging3-1		BE
150	QC21-SA	4 Ea		2/26/18	0.00	0.00	QC21		BE

Part Op 100 - Cut D2600-5 to length as per Dwg D2654-2 Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654 3-
Descriptions: Using the uni-bit, open holes to finish size as per Dwg D2654 4-Debur holes and ends
140 - LOCATION : LG002

APR 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	4 Ea (1 ea)	90-Start up Operation	B145 248

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-5-108	4	118	0

Part Specifications

Specifications could not be found.

Plex 2/13/18 10:31 AM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S060133



Part: D2654-1

Job No: 172155

Serial No/Batch: S060133

Revision:

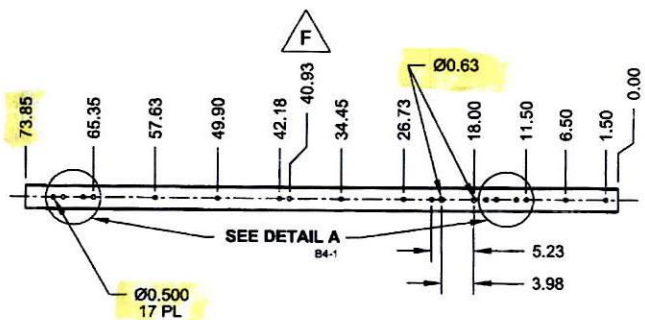
Inspector:

Date: 04/11/16

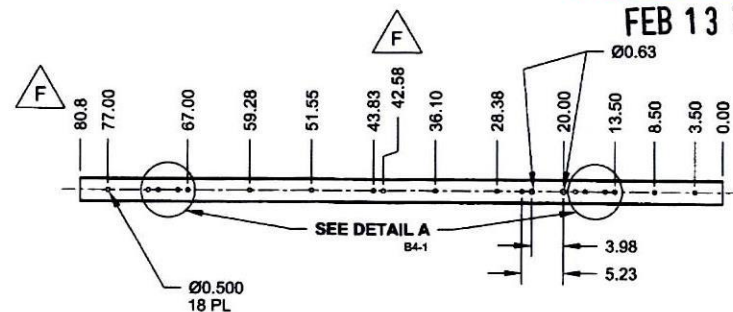
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172155 *md*

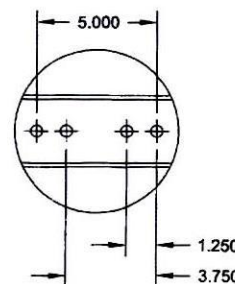
FEB 13 2018



D2654-1 WEB



D2654-3 WEB



DETAIL A

C2-1
C3-1
C6-1
C8-1
D3-2
D6-2
B3-2
B6-2

RELEASED
2011-09-12 *W*

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.28
A	NEW ISSUE	CP	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>g</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>E</i>	D2654	SHEET 1 OF 2
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	WEB	NT
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			